

3040-750

Work Order ID 133571

133571

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Wednesday, June 10, 2015 1:05:35 PM

Item ID: D5152-5 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Fwd Step Post

Start Date: 6/10/2015 Start Qty: 20.00 *20* Cust Item ID:

Required Date: 6/10/2015 Req'd Qty: 20.00 *20* Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUN 10 2015 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5152	B

100

0.00

100

DOOSAN LATHE

0.00

Doosan

Memo

Doosan Lathe

1- Turn as per Folio FB

Rev: AA &
Dwg Rev: B

20 0 JFC 2015-06-13

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

Quality Control

0.00

20 0 JFC 2015-06-13

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Item ID: D5152-5 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Step Post
 Start Date: 6/10/2015 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 6/10/2015 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							DAS 08 9-89
120									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>WA002</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION: WA001								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

***20** **MAL** **#15-07-14**

MCS **JUL 14 2015**

MCS **JUL 14 2015**

Picklist Print

Wednesday, June 10, 2015 1:05:38 PM

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Work Order ID: 133571

133571

Parent Item: D5152-5

D5152-5

Parent Item Name: Fwd Step Post

Start Date: 6/10/2015

Required Date: 6/10/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 15-01-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased		No			f	46.1100		1			

M304RO 750

304 SS Roundbar .750

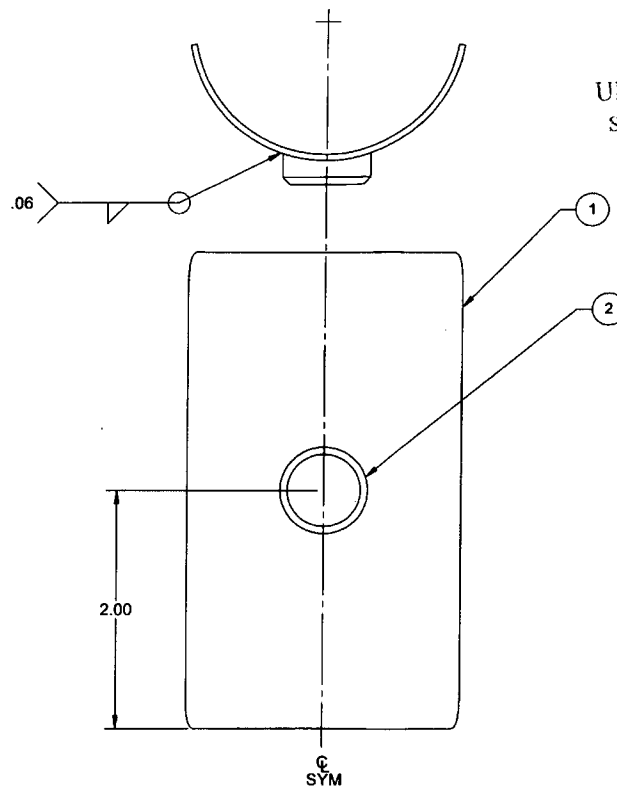
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT029	46.11	
M128005	0.247	
<u>M128496</u>	45.863	

LOTT JFC 2015-06-13

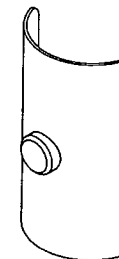
INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	15.04.27	New Issue	KJ 	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5152-041	FWD POST MOUNT ASSY
1	1	D5152-1	FWD POST MOUNT
2	1	D5152-5	FWD STEP POST



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
NO. 133571.MC
1506-10



D5152-041 FWD POST MOUNT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-041= 0.21 lbs

RELEASED

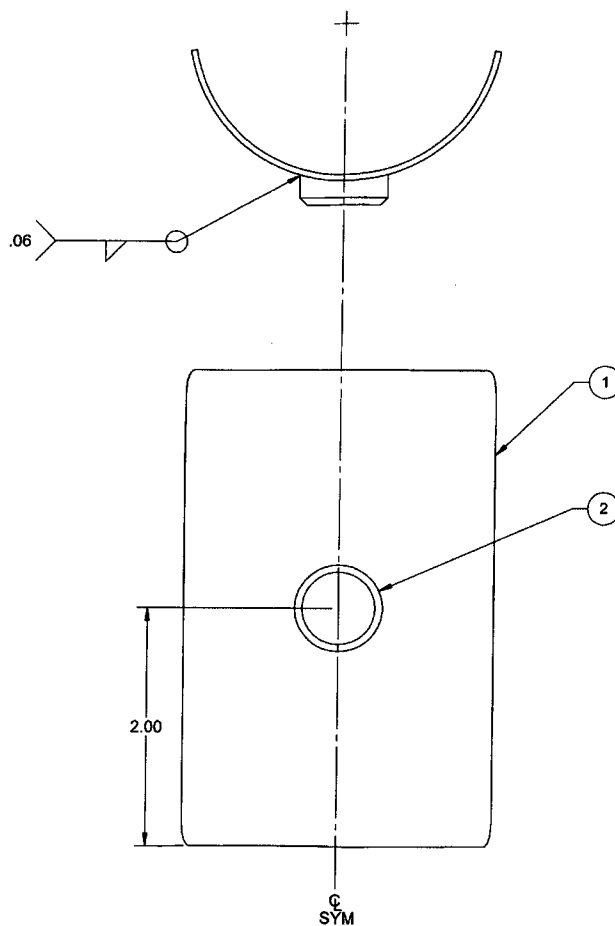
2015 FEB 09

ECN 15-516 4

B	COMPLETE REDESIGN, SEE PREVIOUS REV FOR DETAILS	DB	15.01.09
A	NEW ISSUE	DB	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
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APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5152-043	AFT POST MOUNT ASSY
1	1	D5152-3	AFT POST MOUNT
2	1	D5152-7	AFT STEP POST



D5152-043 AFT POST MOUNT ASSEMBLY

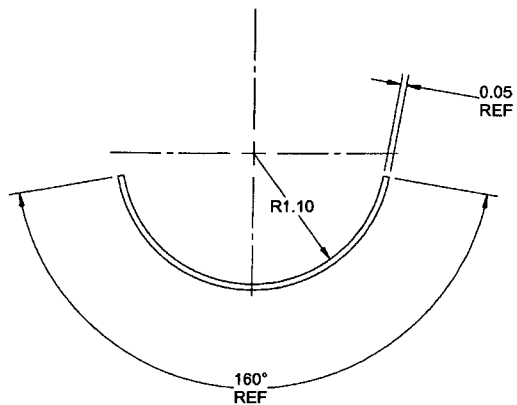
RELEASED

2015 FEB 09

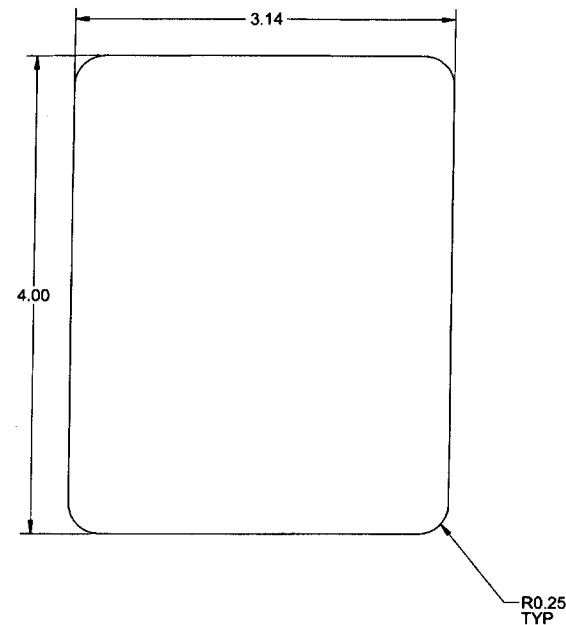
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-043= 0.23 lbs

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	CHECKED	DB	DRAWING NO.	REV. B
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D5152-1 FWD POST MOUNT
(MAKE FROM D5152-1F)



D5152-1F FWD POST MOUNT
(FLAT PATTERN)

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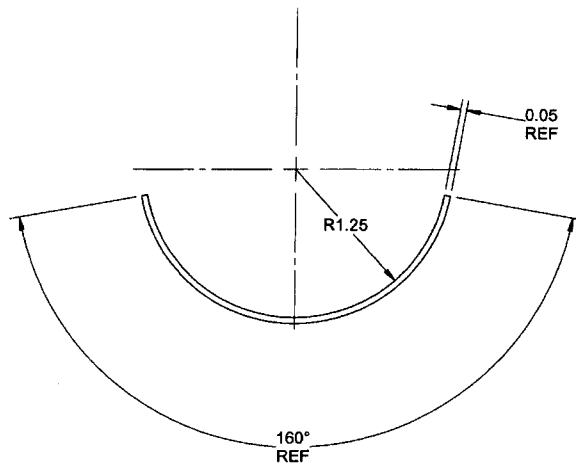
2015 FEB 09

NOTES:

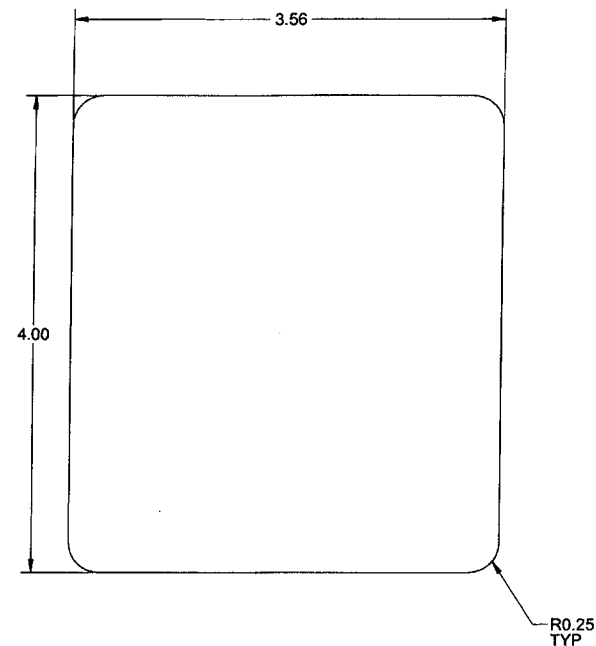
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
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D5152-3 AFT POST MOUNT
(MAKE FROM D5152-3F)



D5152-3F AFT POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5050 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

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8 7 6 5 4 3 2 1

D

C

B

A

R1.150

0.20

0.06 X 45° CMF

Ø0.725

D5152-5 FWD STEP POST

R1.300

0.20

0.06 X 45° CMF

Ø0.725

D5152-7 AFT STEP POST

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

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8 7 6 5 4 3 2 1